



IN THE CLAIMS

Please amend the claims as follows:

Claim 1 (Currently Amended): A method of manufacturing a long-life heat-resisting low alloy steel welded component, ~~including the steps of the method comprising:~~

subjecting a base metal containing, at % by weight, C: 0.15% or less, Si: 0.5% or less, Mn: 0.3 to 0.8%, Cr: 1.9 to 2.6%, Mo: 0.87 to 1.20%, and a balance of iron and unavoidable impurities, to a hot working, to a heat treatment, and then to a welding,

wherein the base metal is normalized once or more times in addition to the original heat treatment before the welding ~~in addition to the hot working~~ so as to reduce an amount of coarse carbides, which have been found to be transformed to be the origin of cause creep damage of type 4 creep damage through the weld heat, remaining-remained in the base metal passed through the original heat treatment only.

Claim 2 (Currently Amended): The manufacturing method according to claim 1, wherein the base metal has been subjected to annealing, or normalizing and tempering.

Claim 3 (Original): The manufacturing method according to claim 1, wherein the base metal is subjected to the hot working in a normalizing temperature range, after the normalizing.

Claim 4 (Original): The manufacturing method according to claim 1, wherein the base metal contains, at % by weight, Mn: 0.3 to 0.6% and Mo: 0.87 to 1.13%.

Claim 5 (Original): The manufacturing method according to claim 4, wherein the normalizing of the base metal is carried out at least twice.

Claim 6 (Currently Amended): A method of manufacturing a long-life heat-resisting low alloy steel welded component, ~~including the steps of the method comprising:~~

subjecting a base metal containing, at % by weight, C: 0.04% to 0.10%, Si: 0.5% or less, Mn: 0.1 to 0.6%, Cr: 1.9 to 2.6%, Mo: 0.05 to 0.3%, V: 0.20 to 0.30%, Nb: 0.02 to 0.08%, W: 1.45 to 1.75%, B: 0.0005 to 0.006% and a balance of iron and unavoidable impurities, to a hot working, to a heat treatment, and then to a welding,

wherein the base metal is normalized once or more times in addition to the original heat treatment before the welding ~~in addition to the hot working~~ so as to reduce an amount of coarse carbides, which have been found to be transformed to be the origin of cause creep damage of type 4 creep damage through the weld heat, remaining remained in the base metal passed through the original heat treatment only.

Claim 7 (Currently Amended): The manufacturing method according to claim 6, wherein the base metal has been subjected to annealing, or normalizing and tempering.

Claim 8 (Original): The manufacturing method according to claim 6, wherein the base metal is subjected to the hot working in a normalizing temperature range, after the normalizing.

Claim 9 (Currently Amended): A method of manufacturing a long-life heat-resisting low alloy steel welded component, ~~including the steps of the method comprising:~~

subjecting a base metal containing, at % by weight, C: 0.2% or less, Si: 1.0% or less, Mn: 0.3 to 0.9%, Cr: 0.3 to 1.5%, Mo: 0.4 to 0.7%, and a balance of iron and unavoidable impurities, to a hot working, to a heat treatment, and then to a welding,

wherein the base metal is normalized once or more times in addition to the original heat treatment before the welding ~~in addition to the hot working~~ so as to reduce an amount of coarse carbides, which have been found to be transformed to be the origin of cause creep damage of type 4 creep damage through the weld heat, remaining remained in the base metal passed through the original heat treatment only.

Claim 10 (Currently Amended): The manufacturing method according to claim 9, wherein the base metal has been subjected to annealing, or normalizing and tempering.

Claim 11 (Original): The manufacturing method according to claim 9, wherein the base metal is subjected to the hot working in a normalizing temperature range, after the normalizing.

Claim 12 (Original): The manufacturing method according to claim 9, wherein the base metal contains, at % by weight, Mn: 0.3 to 0.6%, Cr: 0.5 to 1.5% and Mo: 0.40 to 0.65%.

Claim 13 (Original): The manufacturing method according to claim 9, wherein the base metal further contains, at % by weight, V: 0.22 to 0.50%.

Claim 14 (Currently Amended): A long-life heat-resisting low alloy steel welded component manufactured by ~~the steps of~~ a method comprising:

subjecting a base metal containing, at % by weight, C: 0.15% or less, Si: 0.5% or less, Mn: 0.3 to 0.8%, Cr: 1.9 to 2.6%, Mo: 0.87 to 1.20%, and a balance of iron and unavoidable impurities, to a hot working, to a heat treatment, and then to a welding,

wherein the base metal is normalized once or more times in addition to the original heat treatment before the welding ~~in addition to the hot working~~ so as to reduce an amount of coarse carbides, which have been found to be transformed to be the origin of creep cause damage of type 4 creep damage through the weld heat, remaining remained in the base metal passed through the original heat treatment only.

Claim 15 (Currently Amended): The heat-resisting low alloy steel welded component according to claim 14, wherein the base metal has been subjected to annealing, or normalizing and tempering.

Claim 16 (Original): The heat-resisting low alloy steel welded component according to claim 14, wherein the base metal is subjected to the hot working in a normalizing temperature range, after the normalizing.

Claim 17 (Original): The heat-resisting low alloy steel welded component according to claim 14, wherein the welded component can be applied to at least one of longitudinal joint and circumferential joint of pipes, vessel, valve casing and branch pipes that are used under a high-temperature and high-pressure steam atmosphere at a temperature of 450°C or higher.

Claim 18 (Original): The heat-resisting low alloy steel welded component according to claim 14, wherein the base metal contains, at % by weight, Mn: 0.3 to 0.6% and Mo: 0.87 to 1.13%.

Claim 19 (Original): The heat-resisting low alloy steel welded component according to claim 18, wherein the normalizing of the base metal is carried out at least twice.

Claim 20 (Currently Amended): A long-life heat-resisting low alloy steel welded component manufactured by ~~the steps of~~ a method comprising:

subjecting a base metal containing, at % by weight, C: 0.04% to 0.10%, Si: 0.5% or less, Mn: 0.1 to 0.6%, Cr: 1.9 to 2.6%, Mo: 0.05 to 0.3%, V: 0.20 to 0.30%, Nb: 0.02 to 0.08%, W: 1.45 to 1.75%, B: 0.0005 to 0.006% and a balance of iron and unavoidable impurities, to a hot working, to a heat treatment, and then to a welding,

wherein the base metal is normalized once or more times in addition to the original heat treatment before the welding ~~in addition to the hot working~~ so as to reduce an amount of coarse carbides, which have been found to be transformed to be the origin of cause creep damage of type 4 creep damage through the weld heat, ~~remaining~~ remained in the base metal passed through the original heat treatment only.

Claim 21 (Currently Amended): The heat-resisting low alloy steel welded component according to claim 20, wherein the base metal has been subjected to annealing, or normalizing and tempering.

Claim 22 (Original): The heat-resisting low alloy steel welded component according to claim 20, wherein the base metal is subjected to the hot working in a normalizing temperature range, after the normalizing.

Claim 23 (Original): The heat-resisting low alloy steel welded component according to claim 20, wherein the welded component can be applied to at least one of longitudinal joint and circumferential joint of pipes, vessel, valve casing and branch pipes that are used under a high-temperature and high-pressure steam atmosphere at a temperature of 450°C or higher.

Claim 24 (Currently Amended): A long-life heat-resisting low alloy steel welded component manufactured by ~~the steps of~~ a method comprising:

subjecting a base metal containing, at % by weight, C: 0.2% or less, Si: 1.0% or less, Mn: 0.3 to 0.9%, Cr: 0.3 to 1.5%, Mo: 0.4 to 0.7%, and a balance of iron and unavoidable impurities, to a hot working, to a heat treatment, and then to a welding,

wherein the base metal is normalized once or more times in addition to the original heat treatment before the welding ~~in addition to the hot working~~ so as to reduce an amount of coarse carbides, which have been found to be transformed to be the origin of cause creep damage of type 4 creep damage through the weld heat, remaining remained in the base metal passed through the original heat treatment only.

Claim 25 (Currently Amended): The heat-resisting low alloy steel welded component according to claim 24, wherein the base metal has been subjected to annealing, or normalizing and tempering.

Claim 26 (Original): The heat-resisting low alloy steel welded component according to claim 24, wherein the base metal is subjected to the hot working in a normalizing temperature range, after the normalizing.

Claim 27 (Original): The heat-resisting low alloy steel welded component according to claim 24, wherein the welded component can be applied to at least one of longitudinal joint and circumferential joint of pipes, vessel, valve casing and branch pipes that are used under a high-temperature and high-pressure steam atmosphere at a temperature of 450°C or higher.

Claim 28 (Original): The heat-resisting low alloy steel welded component according to claim 24, wherein the base metal contains, at % by weight, Mn: 0.3 to 0.6%, Cr: 0.5 to 1.5% and Mo: 0.40 to 0.65%.

Claim 29 (Original): The heat-resisting low alloy steel welded component according to claim 24, wherein the base metal further contains, at % by weight, V: 0.22 to 0.50%.

SUPPORT FOR THE AMENDMENT

Claims 1, 2, 6, 7, 9, 10, 14, 15, 20, 21, 24, and 25 are currently amended.

The claims have been amended for minor editorial purposes, and for clarification of the features of the manufacturing of the claimed method, to overcome the rejection for indefiniteness.

The amendments to the claims are supported throughout the present specification, Examples, and Figures, as originally filed.

No new matter is believed to have been added. Accordingly, entry of the amendment is requested.

Upon entry of the amendment, claims 1-29 will be pending in this application.